Work Order ID 98923 *98923* Page 1 March-28-13 10:43:10 AM Item ID: D2965-3 Accept *N900040100* Setup Start Revision ID: Stop *NS2* Item Name: Cap *20* Start Qty: 20.00 Start Date: 3/27/13 Cust Item ID: Required Date: 3/27/13 Reg'd Qty, 20.00 Customer: Reference: Start Run Date: 13 03-28 Tooling: Process Plan: ML 3 Date: Approvals: Stop QC: SPC (Y/N): Date: Date: Operation Sequence ID/ Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Description Run Hours Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D2965 Rev B 100 0.00 CONVENTIONAL LATHE +MILL A *100* 0.00 Lathe Conv Memo Turn as per Dwg D2965 Conventional Lathe USE DT9536 PLUG 110 QC2- Inspect parts off machine FAI/FAIB 0.00 *110* 0.00 Memo Quality Control 0.00 120 QC8- Inspect parts - second check *120* 20 0.00 Memo

Quality Control

										DQA:	Da	ate:	
NCR: Y	es / No				WORK ORDER NON-	100	VFOR	MANCE / UPE	DATE			*	-
										QA Closed:	Da	ate:	
Work Orde	r:				DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	*	
Part N	0				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other	
Root	1			Descri	ption of work order update	Т	nitial	Acti	ion	Sign &	110		
Cause	Date	Step	Qty	l .	or Non-conformance		ief Eng			Date	Verificatio	on QC Inspect	or
Doc/Data				Tocas	er Lug ive & Inspect					cL			
quip/Tooling		90		£3500		T				13/04/16			
Operator	_	40		Cost &	erdug					13/07/19			
Material	1			0						1/1		10-1	
Setup	- The May	91		Recei	ue & Inspect					13/0/3	(20)		
Other	1,0	2/1				-				1993			
Process Supplier	-1,p.	00		Qc 6						as.			
Fraining	-\ \ '	97		ace						3	20		
Jnapproved								ŀ		1353			
					F	AUL	T CATE	GORY					
Landin	g Gear				General			1. OCE	£? -				
_[Bending				Bend		Grain	SIGN OFF SEE OHER WITH MC	Date	Ovalized		Pressure/Forced	i.
	Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardw	CE NHER	1040	Over/Under	tolerance	Temperature/Cu	ıre
	Cracks				Broken/Damaged		Inspec	TE CITY	05	Part Incorred	ct	Weld	
- 2	Crushed/	Crimped			Burrs		Instruc	With In	M	Part Lost/Mi	ssing	Wrong Stock Pul	lled
	Cuffs				Contamination		Maint	400.		Part Moved			
UT	Heat Trea	it			Countersink		Mislabe	900.	-	Positioned V	Vrong		
	Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other	
	Ripples in	Bend			Drill Holes	16	Offset		.te				
1	Torque W	laves in E	xtrusio	n	Drawing	N	Out of 0	Calibration					
[Turning S	equence			Finish	12	Out of S	Sequence					
	Wave/Tw	ist in Tub	e		Folio		Outside	Dimensions					

Work Order ID 9			*989	23*		2	September 1	I	Page 2
Item ID: Revision ID: Item Name: Start Date: 3/27/13	Start Qty: 20.00	*20*	Accept	*N9000	40100)* s	Stop	*NS1	
Required Date: 3/27/13 Reference:	Req'd Qty: 20.00	*20*		Customer:	E .				
Approvals: Process QC:	Plan:	Date:	Tooling: SPC (Y/N):	Date:		R	un Start Stop	*NR1)* -
Sequence ID/ Work Center ID 130 *120* Small Fab Small Fab	Operation Description Small Fab Memo Drill as per I	Dwg D2965 with DT8538I	Set Up/ Run Hours 0.00 0.00 Deburr and Tumble	Tool ID T	Fool # Plan Code	Accept Qty			
*140 *140* QC Quality Control	QC5- Inspect part comple	eteness to step on W/O	0.00			3 0		nla	113.08.1
*150 *150* Powdercoat Powder Coating	Powdercoat Memo START TIM	83	0.00 0.00 OVEN TEMPERATURE:		2	XX	mif	13/09	\$6
MI 26125	3200	FINISH TIME:	9:30		20%	191	m-fi	3/09/	126

DQA:

Date:

NCR: Yes	s / No				WORK O	RDER NON-C	ONFOR	MANCE / UP	DATE			
100000000000000000000000000000000000000	- 0.00	4	Aug.p	+	AND THE SECOND STREET STREET,					QA Closed:	Date:	
Work Order:	N			*	DIS	POSITION			AGAINST DE	PARTMENT	/PROCESS	o€i
Part No					Work C	Rework Scrap Use-as-is		Skid-tube Machining Moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descr	iption of work	order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-confor	rmance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	3,09.2	4100	20	DUE END QFL	131 NOT TO USI MILL TO M NEF. Openator Dis	3 OF MICHUE	1504.24 1500 1500	PARTS AC	CEPTAGLE	/13/02/24	13/09/E4	DAS 16 9-89
						F/	AULT CATE	GORY				
Landing	Gear Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection Ripples in Torque W Turning So Wave/Tw	Crimped of	Tube Extrusio	a .	Bend BOM/Route Broken/Dam Burrs Contaminatio Countersink Cut Too Short Drill Holes Drawing Finish Folio	naged	Instruct Mainte Mislabe Misreae Offset Out of Out of	ion Incomplete tions Incomplete/ enance eled	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Work Order ID 98923 *98923* Page 3 March-28-13 10:43:10 AM Item ID: D2965-3 Accept *N900040100* Setup Start Revision ID: Item Name: Cap Start Oty: 20.00 Start Date: 3/27/13 Cust Item ID: Required Date: 3/27/13 Reg'd Oty: 20.00 Customer: Reference: Run Start Process Plan: Tooling: Date: Date: Approvals: Stop SPC (Y/N): QC: Date: Date: Accept Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Insp. Work Center ID Description Code Qty Qty Number Stamp Run Hours 160 QC3- Inspect Part Finish 0.00 *160* 0.00 Memo Quality Control 0.00 170 Small Fab *170* d el vslor 130 0.00 Small Fab Memo Install Inserts as per Dwg D2965 Small Fab 180 QC5- Inspect part completeness to step on W/O 0.00 *180* 0.00

Memo

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

, 1		
DQA! AWY LE	ate;	
h	10//	
Closed:	Date: 13/10/0	

										QA Closed.	The Date.	11111
Work Order:	0/81	923			DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No.	D20 13-				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	2 VOTO 100	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root Cause	Date	Step	Qty	11	ption of work order update or Non-conformance		nitial ief Eng		tion cription	Sign & Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other, Process Supplier Training Unapproved	130gray	130	20	AT O	H WIE ZOLATED ABO" IN LIEU OF "MAX. MATERIAL (1582)	_	6810°E 07.24	ACLOPADRE PARTS U TRUAL P SKLITURE	DEVIATION ON	Shole	FX- 13)00/24	DAS 16 9-89 13 (10/22
					F.	AUL	T CATE	GORY		_		•
Landing	Gear Bending Centre No	ot Conce	ntric to (o/s	General Bend BOM/Route	\vdash	Grain Hardwa	re		Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
	Cracks Crushed/ Cuffs				Broken/Damaged Burrs Contamination		Instruct Mainte		'Unclear	Part Incorred Part Lost/Mi Part Moved	ssing	Weld Wrong Stock Pulled
	Heat Trea Inspectio Ripples in	n Strip in	Tube		Countersink Cut Too Short Drill Holes		Mislabe Misread Offset			Positioned V Power Loss/		Other
	Torque W		extrusion	1	Drawing		Out of C	Calibration				
	Turning S	equence			Finish		Out of S	equence				
	Wave/Tw	ist in Tub	oe		Folio		Outside	Dimensions				

Work Order ID 98923

Quality Control

98923

Page 4

March-28-13 10:43:10 AM Item ID: D2965-3 Accept *N900040100* Setup Start Revision ID: Stop Cap Item Name: *20* Start Date: 3/27/13 Start Qty: 20.00 Cust Item ID: Required Date: 3/27/13 Req'd Qty: 20.00 Customer: Reference: Run Start Approvals: Process Plan: Date: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Accept Reject Insp. Qty Qty Work Center ID Description **Run Hours** Code Number Stamp Identify as per dwg & Stock Location: FP 190 0.00 -MK_ 13-9-30 *100* Packaging 0.00 Memo Packaging Rm 13/09/30 QC21- Final Inspection - Work Order Release 0.00 200 *200* 0.00 Memo

MF 9.30

											DQA:	Date:	
NCR: Y	es	/ No				WORK ORDER NON-O	cor	VFORM	MANCE / UPD	DATE			- 3 :
											QA Closed:	Date:	
Nork Orde	r:					DISPOSITION				AGAINST D	EPARTMENT,	PROCESS	8
						Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Therm	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo.					Work Order Update			Large Fab	Composite		Supplier	
200	_									•	T at a		
Root		5 -	C 1	0.	Descr	ription of work order update		nitial	Acti		Sign &	V - 'C - V	001
Cause	-	Date	Step	Qty		or Non-conformance	Cn	ief Eng	Descri	iption	Date	Verification	QC Inspector
oc/Data	-												
quip/Tooling perator													
Material	Н												
etup													
ther													
rocess													
upplier													
raining													
napproved													
						F	AUL	T CATE	GORY				
Landi	ng (Gear			_	General	_	,		-	_	_	
		Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	O/S	BOM/Route		Hardwa			Over/Under	_	Temperature/Cure
		Cracks				Broken/Damaged			on Incomplete		Part Incorred	_	Weld
		Crushed/0	Crimped		-	Burrs	-	O VIII THE THE	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte		-	Part Moved		
		Heat Trea			-	Countersink	-	Mislabe		-	Positioned V		1
		Inspection		Tube	-	Cut Too Short		Misread		L	Power Loss/	Surge	Other
		Ripples in		C11#000-51-0#-	_	Drill Holes	-	Offset	No. P. Carrier				
		Torque W			n	Drawing	-		Calibration				
	1 1	Turning S	equence		- 1	Finish		Out of S	Sequence				

Outside Dimensions

Wave/Twist in Tube

Folio

· Picklist Print

March-28-13 10:43:10 AM

Work Order ID:

98923

Parent Item:

D2965-3

Parent Item Name:

Cap

Start Date: 3/27/13

Required Date: 3/27/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev A New Issue 06-12-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty po	er Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			110	Each	1,476.0000	1	2	40	11	1	
INSERT														
				Location	· ·	Loc Qty	Lo	c Code						
				FG		90								
				118:	520	90	111	12595	SO	V2	U			
				FP001		45								
				118:	520									
				1222	290	16 29								
				ST280		266								
				122	290	266								
				ST281		1075								
				100	396	135								
				122	333	940	9							
D2965P		Purchased	No			170	Each	0.0000		L	20			
Сар														

DQA: Date: WORK ORDER NON-CONFORMANCE / UPDATE Yes / No NCR: QA Closed: Date: AGAINST DEPARTMENT/PROCESS DISPOSITION Work Order: Water Jet Engineering Rework Skid-tube Crosstube Machining Small Fab Prod. Eng. Coor. Part No. Scrap Use-as-is Thermoforming Finishing Rec/Store/Packaging Supplier NCR No. Work Order Update Large Fab Composite Description of work order update Action Initial Sign & Root or Non-conformance Chief Eng Description Qty Date Verification Cause Date Step Doc/Data Equip/Tooling Operator Material

Setup Other Process Supplier Training Unapproved

Landing Gear

Bending

Cracks

Crushed/Crimped

Centre Not Concentric to O/S

Quality

Other

QC Inspector

Pressure/Forced

Weld

Temperature/Cure

Wrong Stock Pulled

Cuffs	Contamination	Maintenance	Part Moved
Heat Treat	Countersink	Mislabeled	Positioned Wrong
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge Other
Ripples in Bend	Drill Holes	Offset	
Torque Waves in Extrusion	Drawing	Out of Calibration	
Turning Sequence	Finish	Out of Sequence	
Wave/Twist in Tube	Folio	Outside Dimensions	

FAULT CATEGORY

Grain

Hardware

Inspection Incomplete

Instructions Incomplete/Unclear

Ovalized

Part Incorrect

Part Lost/Missing

Over/Under tolerance

General

Bend

Burrs

BOM/Route

Broken/Damaged

DART AEROSPACE LTD	Work Order:	98923
Description: Cap	Part Number:	D2965-3
Inspection Dwg: D2965 Rev: B		Page 1 of 1

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection		nments
1.000	+/-0.010	0.993	V		410-09	12	em
R0.250	+/-0.010	0, 260	1		1910-04		un
# F		76			- 1	glille	7.5
R0.031	+/-0.010	-				+ -	
3.040	+/-0.010	3.030	/		1418-04	W.	na .
3.170	+0.000/-0.010	3,030	/		MIP-04	Ve	
		- P - N - N - N - N - N - N - N - N - N			4.		
Ø0.297	+0.006/-0.001	.301	7		Fith	Ver	
0.400 - 0.370	N/A	.450			0	· be	
	7	-/A.					
						Mary .	
	1 -						
	T. 3						
o Sovedijk i							
7 5 6							
14, 4-7,							
19							
11.5				2.			
		-					
1)-			No. 753				
			DAS 1-				
Measured by:	hill	Audited by:	3-0	1	Prototype /	DE-ENTI-STEEL SALV	N/A
Date: /	3/08/12	Date:	13/08	13		Date:	N/A



Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19591

Purchase Order Date 4/16/13 PO Print Date 4/16/13

Page Number 1 of 1

Order From:

VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD. 2225 CHEMIN ST. FRANCOIS

DORVAL, QC H9P 1K3

CA

Contact Name

Vendor Phone

514 683 9777

Vendor Fax

514 683 0375

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr Terms

Net 30 CAD

Currency FOB

Destination-Collect

Chantal Lavoie

10127-2607

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA



Line Nbr Reference Description/ Req Date/ Req Qty/ Ship Method Unit Price Extended Revision ID Mfg ID Taxable Unit of Measure Price Vender Part Number D2965P Cap 4/30/13 30.00 FedEx PI collect \$21.2000 \$636.00 Yes Each Special Inst: AS PER DWG D2965 REV. B B99551

D2965P

Cap

4/30/13 Yes

20.00

Each

FedEx PI collect

\$21,2000

\$424.00

Special Inst:

AS PER DWG D2965 REV.B B98923

PO Total:

\$1,060.00

MATERIAL CERTIFICATION REQ'D UPON DELIVERY

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required YES NO

Change Nbr:

Change Date: 4/16/13

Aluminum Foundry Ltd 2225 Chemin St. Francois Dorval, Québec H9P 1K3 Tel: (514) 683-9777 Fax: (514) 683-0375

email: info@foundryafpw.com

Packing Slip

Packing Slip No.:

34295

Shipped Date:

30 04 2013

Sold to:	P. C.	Ship to:	
Service and an arrange	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel. (613) 632-5200 Fax (613) 632-5246	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7	
Order No	.: 19591		
Shipped	Ву:		
Tracking	No.:		

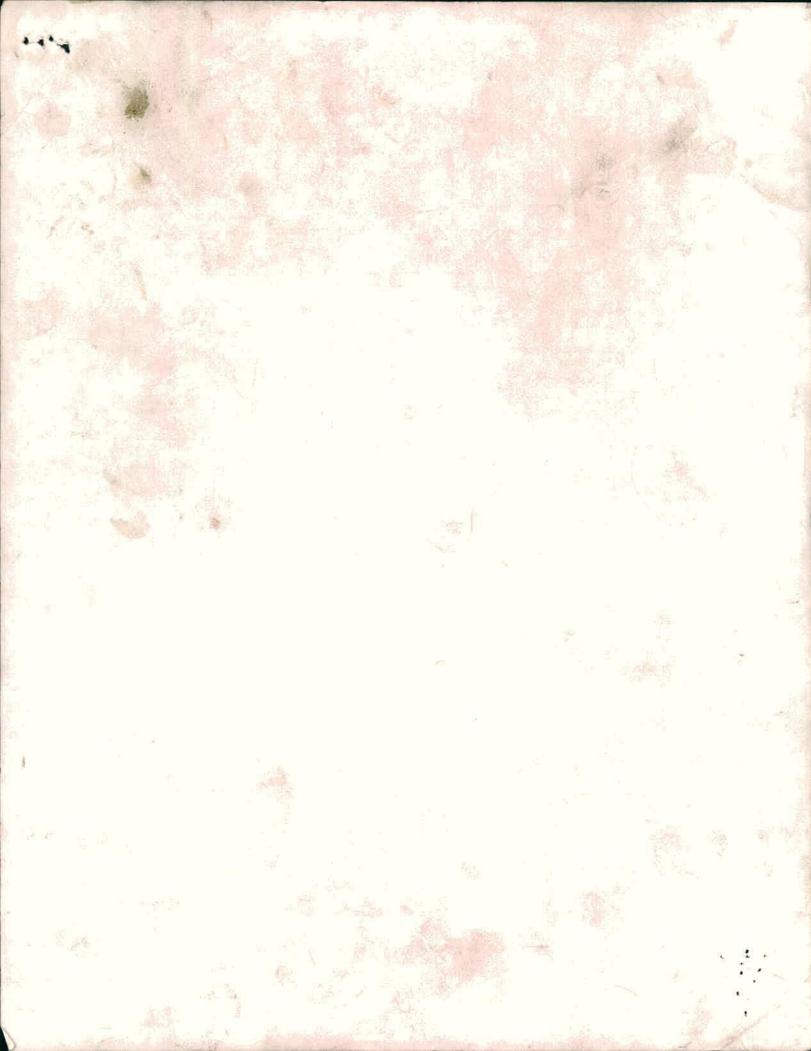
Unit		Description		Quantity
Each	D2965 CAP			58
5				
h 4 hd				
7	Received by:			
	Date:			
	Each	Each D2965 CAP	Each D2965 CAP	Each D2965 CAP

CERTIFICAT DE CONFORMITÉ CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

25 CHEMIN ST. FRANCOIS, DORVAL, QC H9P-1k3 TEL :(514) 683-9777 FAX: (514) 683-0375

Expédié à	1270 Aberdeen Street		A.F. & P.W.Série no./Serial no. Packing Date: 30/04/2013 Slip No. 34295			
Shipped -						
	Hawksbury, ON, K6.	A 1K7		o. Commande rder No	19591	
documents e This is to cer	r certifié que le material liste ci-d n evidence des rapports et certif tify that the material et ac gelow he tests or release ac est des fr	ficates di détaillan	ite sont e	en filiere dans r	otre burea	u.
Quantite Quantity	Descriptio	Notre No. Our No.		Specification	3	Note d'autorisation Incoming Release not
58	D 2965 CA₽	Z200080		A356.2		ingot#C625-0820 B# 1311301
Analyse Analysis (as i (SI) (Fe) (Cu) (Mn) (Mg) (Zn) (TI)	6.9% (A1) nce 0.11% <0.01% <0.01% 0.39% <0.01% 0.11%					
Donne Yleid :	Résistence e la familie : Tensile Strength :		ur et au n	Allongement P.S.I. Elongar		earré :
Coc-100		For FO ALU De	and on t	ehalf of :	M ET MOD	ELERIE (1988) LTEE WORKS (1988) LTD



	In the same					
	06.11.01	CHECKED	PH PH			
		APPROVED A	PH PH			
1	0	D PR	-			

2965 P AWING NO.

AEROSPACE L

USA, NC.

2 OF 2 REV. B SCALE

DART

2.12.12 RELEASEL

1.00 FROM END (NO PAINT) Ø0.297 INSTALL AELS-1032-130 AFTER FINISH (2 PLACES)

MASK

D2965-3 FINISH DETAIL

D2965-3 CAP 1)

D2965-3 CAP MACHINING DETAIL

(MAKE FROM D2965 CAP)

RO.250

0.500

ø3.170+0.000

1.000

R0.031

3.040

MATERIAL: MAKE FROM D2965 CAP

POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 FINISH:

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE INCHES

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OR.

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COCUMENT.

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